Work Order	ID	59509
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QC

**Quality Control** 

Friday, June 04, 2010 3:03:03 PM



Page 1

B10-6-10

Item ID: D4008-043 Accept Setup Start **Revision ID:** Stop Item Name: Fuel Pump Splash Guard Assembly **Start Date: Start Qty:** 1.00 6/4/2010 **Cust Item ID:** Required Date: 6/10/2010 Req'd Qty: 1.00 **Customer:** Reference: Start Run Date://260 Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Qty Qty Code Number Stamp **Draw Nbr Revision Nbr** D4008 Α 100 0.00 12 10-6-10 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg (D4008-3) Dwg Rev: 364 360, Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00

0.00

Memo

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W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHAP	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		1								
Part No	:	PAR #:	Fault Categ	ory:	NCF	R: Yes	No DQ	<b>A:</b>	_ Date: _	
	R	esolution:	Disposition	:	QA:	N/C CIC	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	)			
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
<b>J</b> A. L	O121	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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#### Work Order ID 59509

Friday, June 04, 2010 3:03:03 PM



Page 2

Item ID:

D4008-043

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Fuel Pump Splash Guard Assembly

6/4/2010

Start Oty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



**Required Date: 6/10/2010** 

OC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

120

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Run Hours 0.00

Tool ID

Tool # Plan Code Accept Reject Qty

Reject Number

Insp. Stamp

Quality Control

130

Brake NC

**Quality Control** 

Brake NC

Bend as per dwg

0.00

1- Bend as per dwg

2- Dimpled as per dwg

0.00 SB 10/06/16 ES00/08/24@

Oty

140

QC5- Inspect part completeness to step on W/O

0.00

Memo

	•								
W/O:			WO	RK ORDER CHANG	ES	<u> </u>			
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	Jory:	NCR: Yes	No <b>DQ</b>	\:	Date:	
		solution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)		· ·	
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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#### Work Order ID 59509

Fridav. June 04. 2010 3:03:03 PM



Page 3

Item ID:

D4008-043

Accept

Setup Start



**Revision ID:** 

Item Name: Fuel Pump Splash Guard Assembly

**Start Date:** 

6/4/2010

Start Oty: 1.00

Req'd Otv: 1.00

Cust Item ID:

Customer:

Reference:

Approvais:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



**Required Date: 6/10/2010** 

QC:

Date:

SPC (Y/N):

Tool ID

Date:

Code

Tool # Plan

Stop

Reject

Oty

Insp.

Stamp

Sequence ID/ Work Center ID

160

Powdercoat

Powder Coating

Operation Description

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

Oven Temperatu Finish Time:

Set Up/ Run Hours

0.00

0.00

Accept

Qty

Reject

Number

170

OC

OC3- Inspect Part Finish

ES 180101 18 (=

Quality Control

180

Small Fab Small Fab

Memo

Memo

Assemble as per dwg

0.00

0.00

W/O:			wo	RK ORDER CHANG	iES				
DATE	STEP	PROCEDURE CHANGE B					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	s No DC	PA:	Date:	
		olution:							
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DATE	STEP	Description of NC	<del></del>		ion B	Verif	ication	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	& Sec	tion C	Chief Eng	QC Inspector
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#### Work Order ID 59509

Friday, June 04, 2010 3:03:03 PM



Page 4

Item ID:

D4008-043

Accept

Setup Start



**Revision ID:** 

Item Name:

Fuel Pump Splash Guard Assembly

Start Date:

6/4/2010

Start Otv: 1.00

Rea'd Otv: 1.00

**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Tooling:

Date:

Date:

Run

Start Stop

Stop



**Required Date: 6/10/2010** 

OC:

Date:

SPC (Y/N):

**Tool ID** 

Tool # Plan

Accept

Reject

Reject

Insp.

Sequence ID/

Work Center ID

**Ouality Control** 

Operation Description

OC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

Code

Oty Otv Number

Stamp

200

Packaging

**Packaging** 

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

1/10/9/18 (2)

210

QC21- Final Inspection - Work Order Release

0.00

10/09/15 A) MV 10-9-25

**Quality Control** 

Memo

0.00

	-								,
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		olution:							
NCR:		·	WORK ORDE	R NON-CONFORMA	NCE (NCR	)	<del>/</del>		
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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#### **Picklist Print**

Monday, June 07, 2010 10:09:17 AM

Work Order ID: 59509

D4008-043

Parent Item Name:

Fuel Pump Splash Guard Assembly

Comments:

Parent Item:

IPP rev A 10.01.27 New issue Prelim EC verified by:DD

10.05.03 as per ECN10-562 DD verified by:EC

Start Date: 6/4/2010

**Required Date: 6/10/2010** 

Start Otv: 1.00

0.441

Required Otv: 1.00

Component	Item	ID/
Item Name		

M304S24GA

Replacement Mfg/ Item ID Purch Purchased

Bin Primary Item Location No

Last Location Route Seq ID 100

Unit of Otv on Measure Hand 74.0000 sf

Oty per Kit Total Otv

Otv Issued 0.464211

106736

Date Status

Page 1

Issued

B10-6-10

	DANDA MADAN ANTANAN ING MADAN ANTANA DAN
204/216	025 Chast

304/316 .025 Sheet

T acadia	T O.	
<u>Location</u>	Loc Qty	Loc Code

MAT20 74 106236 42 107244

IPP Rev:B

32 Each 4,864.000



MS20426AD3-3



Rivet

Location	Loc Qty	Loc Cod
ST316	4864	

180

180

4864 19099 4774 7681 90

323.0000





Nut

Purchased G10.08,31

Purchased

No

No

Location ST301

112314

12706

Loc Oty 323 200 123

Each

Loc Code

7115396

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DART AEROSPACE LTD	Work Order:	59509
Description: Fuel Young Spirst Guaso ASSEMBY	Part Number:	D4008-043
Inspection Dwg: D400% - Rev:		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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	Measured by:	13	Audited by:	Prototype Approval:	N/A
ł	MEdanica by.	195	18	Date:	N/A
	Date:	10-6-10	Date: 10/06/10	Date.	1477

			Revised by	Approved
Rev	Date	Change	KJ/JLM	
Δ		New Issue	17070214	

SHOP COPY RETURN TO

3

5 ENGINEERING 2 QTY. -041 UNCONTROLLED COPY JOHN CAMERON AVIATION PART NUMBER ITEM NO. **PART NUMBER** DESCRIPTION SUBJECT TO AMENDMENT 1 х D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY JCA-M47-2-26 WITHOUT NOTICE WORK ORDER 9 NO. 59509 BS16-6-07 2 2 D3941-1 RUBBER CUSHION 3 1 D4008-1 FUEL FILLER SPLASH GUARD CHANNEL 4 1 D4008-5 HINGE D 5 2 D4008-7 WASHER 6 D4008-9 1 SPRING 7 5 MS20470AD3-3 RIVET 8 2 MS35206S245 SCREW 9 6 NAS1149DN832J WASHER 10 2 MS21042L08 NUT 10 С **SECTION A-A** С SCALE: 2X A<sub>C2-1</sub> 10 (2)D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY NEW ISSUE Α 10.02.05 REV. DESCRIPTION DATE 1) MATERIAL: NIA
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.15 lbs DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4008 MFG. APPR. SHEET 1 OF 10 APPROVED TITLE SCALE 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT SPLASH GUARD DE APPR. NTS 9) MASK HINGE PIN AREA BEFORE POWDER COAT

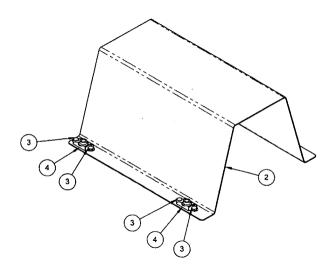
10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT THE COPYRIGHT © 2010 BY DART AEROSPACE LTD
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	Х	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
		-		
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	8	MS20426AD3-3	RIVET	<u> </u>
4	4	MS21059L08	NUT PLATE	
	4	W521059L08	NUT PLATE	l



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

wls 39369

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С

NOTES:
1) MATERIAL:
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.46 lbs

DESIGN		DART AEROSPA	ACE LTD	
DRAWN	<b>45</b>	HAWKESBURY, ONTARIO		
CHECKED	B	DRAWING NO.		
MFG. APPR.	E	D4008	SHEE	
APPROVED	10.	TITLE		
DE APPR.	-#	SPLASH GUARD		
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AE THIS DOCUMENT IS PRIVATE AND COMPRIDENTIAL AND IS SUPPLIED O NOT TO BE USED FOR ANY PURPOSE OR GOOD OR COMMANDAT WHITTEN BETWEEN HER HOME DAY AREA WHITTEN BETWEEN HER HOME DAY AREA	IN THE EXPRESS CONDITION OF THE EXPRESS CONDITION OF THE REPORTS	

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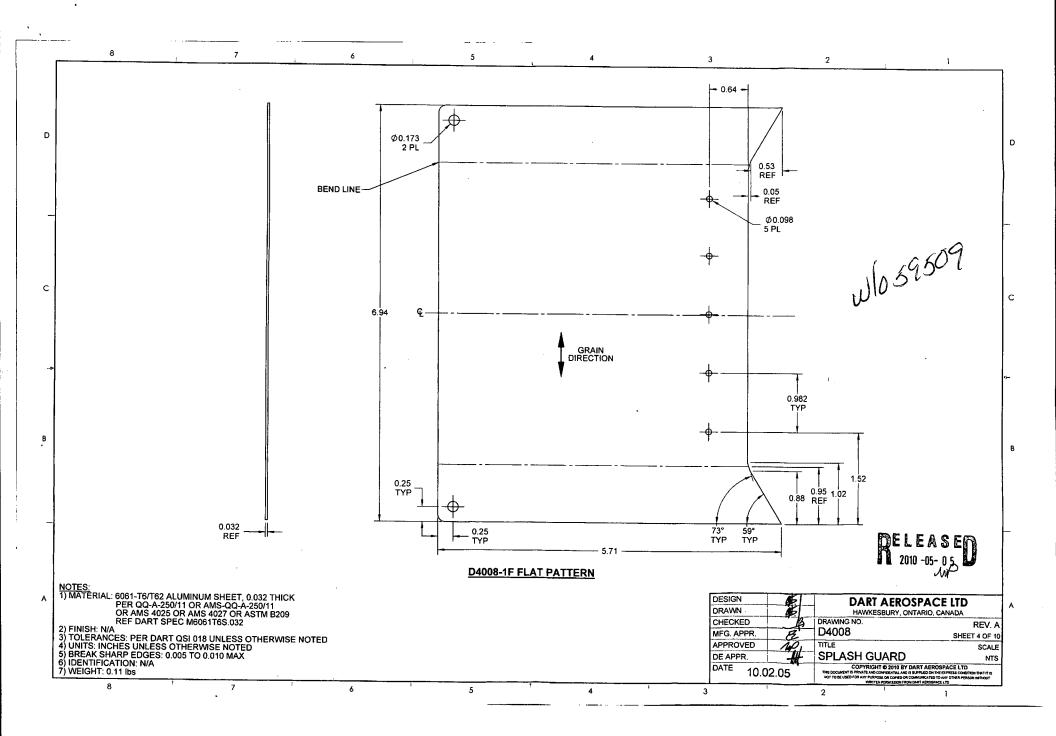
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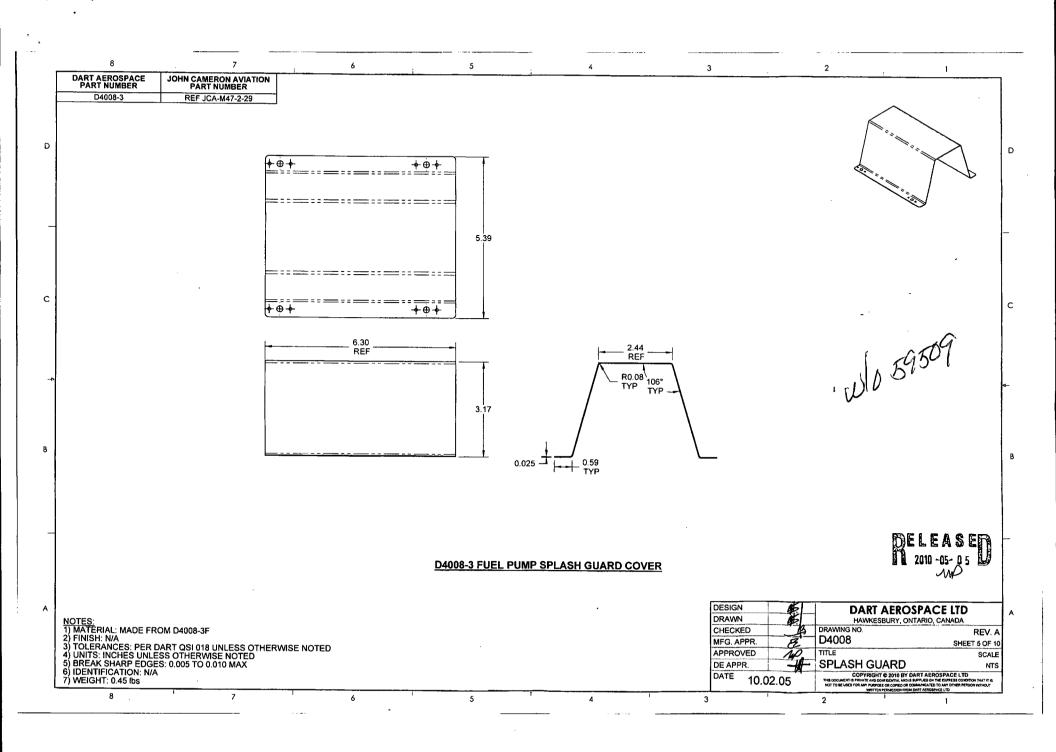
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DATE	STED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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6 5 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4008-1 REF JCA-M47-2-26 Ð 5 12 С С w/o 59509 5.71 REF 59° REF R0.08 0.98 TYP В **D4008-1 FUEL FILLER SPLASH GUARD CHANNEL** DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: MADE FROM D4008-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.11 lbs DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4008 MFG. APPR. SHEET 3 OF 10 TITLE APPROVED SCALE SPLASH GUARD DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS GOCUMENT OR PRINT ME COMPONIUM AND IS SUPPLED ON THE EXPRESS CONDITION TO BE USED FOR ANY PURPOSE OR COPIED OR COMMARCATED TO ANY OTHER PERSONS OF COPIED OR COPIE DATE 10.02.05 7 3

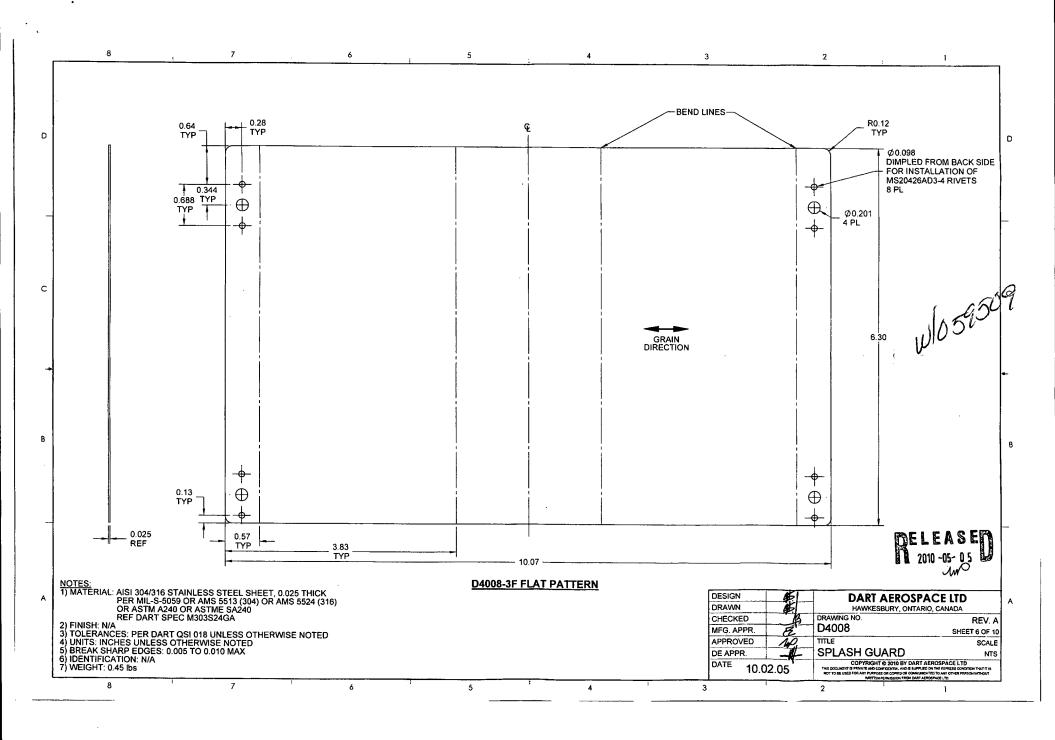
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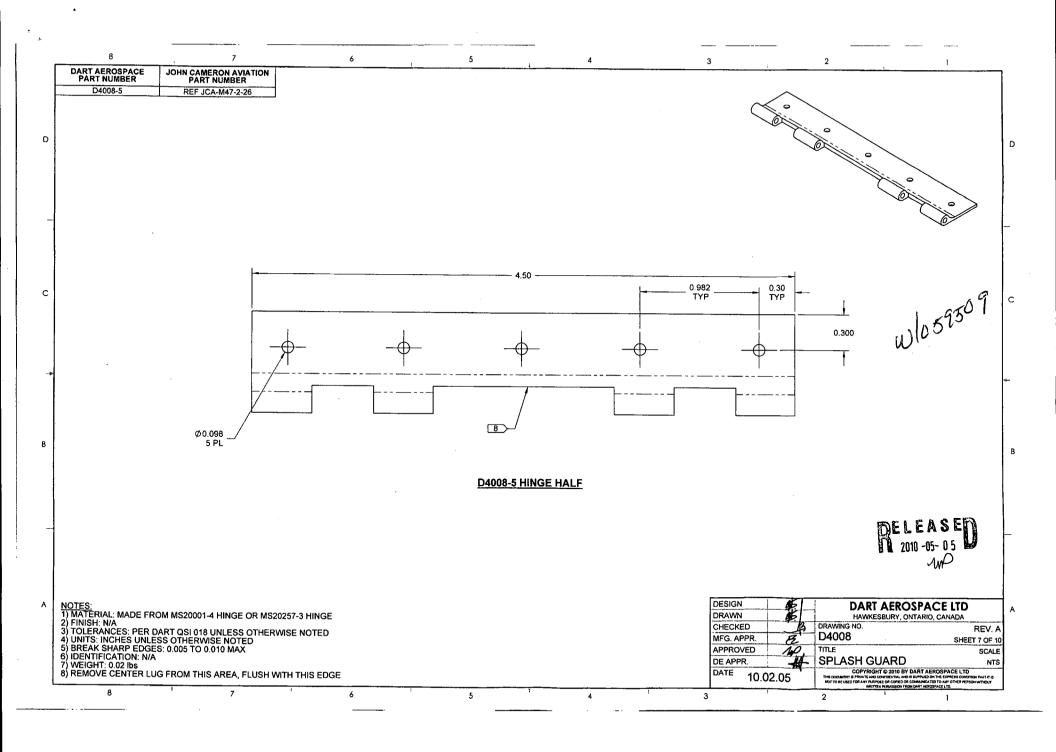
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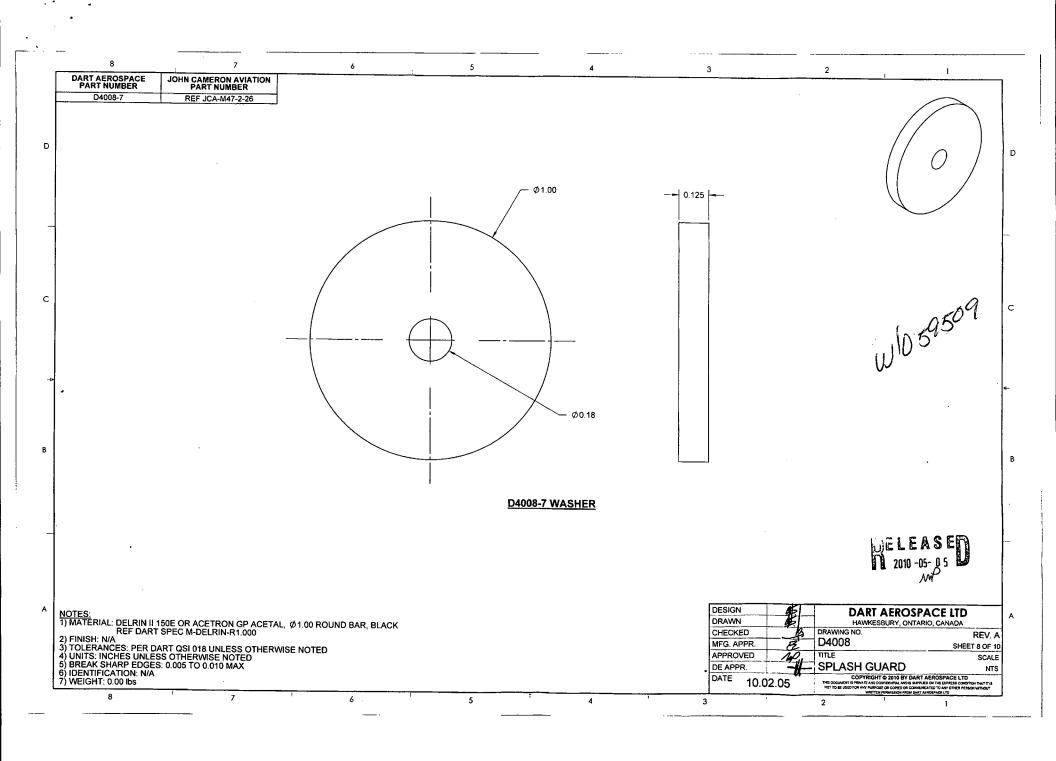
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DATE	STEP	Description of NC		Corrective Action Section B			ation	Approval	Approval
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DATE	STEP	Description of NC			ion B		Verific	cation	Approval	Approval		
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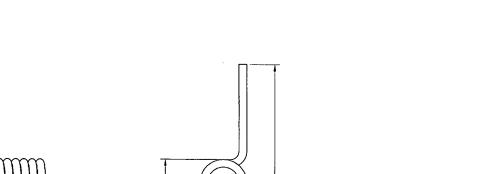
DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4008-9 REF JCA-M47-2-26

D

#### **SPECIFICATION CONTROL DRAWING**

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Ø0.032 REF



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2



DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

#### **D4008-X SPRING**

NOTES:			
1) MATERIAL	T301 OR 304 STAINLES	SS STEEL SPRING WIRE	Ø 0.032 PER ASTM A313

7

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.00 lbs

DESIGN	<b>9</b> 5-1	DART AEROSPA	CE LTD			
DRAWN	45	HAWKESBURY, ONTARIO	, CANADA			
CHECKED	B	DRAWING NO.	REV. A			
MFG. APPR.	Z	D4008	SHEET 9 OF 10			
APPROVED	10.	TITLE	SCALE			
DE APPR.	-#	SPLASH GUARD	NTS			
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS REWITE AND COPEDINAL AND IS SUPPLIED ON THE DEPOSES DOCUMENT INTO THE TOTAL OF THE DEPOSE OF COPIES OF THE DEPOSE OF THE PURPLE				

W/O:			WC	ORK ORDER CHANG	ES				<del>-</del>	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _		
	Re	esolution:	Disposition	n:	_ QA: N/C C	QA: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCI	₹)				
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval Chief Eng	Approval QC Inspector	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	🖔   Secti				
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3 2 D C W/159569 0.51 --TYP D4008-11 TANK HINGE HALF DESIGN Α

NOTES:
1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: STOCK AS D4008-11
7) WEIGHT: 0.02 lbs

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DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D4008 MFG. APPR. SHEET 10 OF 10 APPROVED TITLE SCALE SPLASH GUARD DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			W	ORK ORDER CHANG	ES					* ,
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	ı	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:	Fault Ca	tegory:	NCR: Ye	s No	DQA	.:	Date:	
		esolution:	Disposit	ion:	_ QA: N/C	Clos	ed:			
NCR:			WORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DAIL	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section	n C	Chief Eng	QC Inspector
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